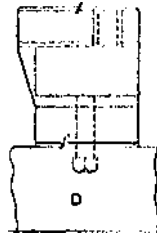


of course, depends entirely upon the size of the work and the size of the holes to be drilled. Sometimes one set-screw is quite sufficient, which, in this case, would be placed in the center, as indicated by the dotted lines in Fig. 4. The type of jig shown in Fig. 7 now possesses all the features

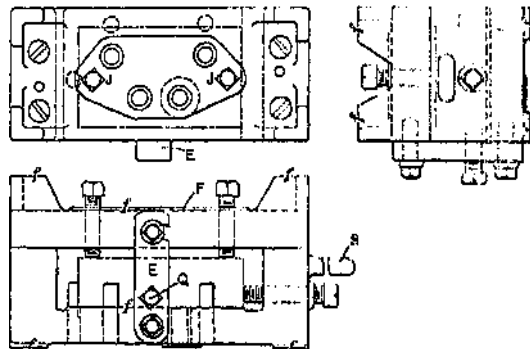
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W—-r

**Fig. 6. Jig in Fig. 4 used in Combination with Two Parallels**

generally required for a good jig, and presents a type which is largely used in manufacturing plants, particularly for medium and heavy work. The jig shown in Fig. 8, however, represents another type, somewhat different from the jig in Fig. 7. The



**Fig. 7-**

# Jig improved by Adding Feet opposite containing Drill Bushings

jig in Fig. 7 is composed of two large separate pieces, which, for large jigs, means two separate castings, involving some extra expense in the pattern-shop and foundry. The reason for making the jig in two parts, instead of casting it in one\*, is because it makes it more convenient when machining the jig. The local-